

Work Order ID 59739 - 2

Thursday, June 10, 2010 10:38:48 AM



Page 1

Item ID: D3262-5

Accept



Setup Start



Revision ID:

Item Name: Cap

Stop



Start Date: 6/11/2010 Start Qty: 10.00

Required Date: 6/18/2010 Req'd Qty: 10.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *MR*

Date: 10-6-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3262

E

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 6.000" x 0.500" x 5.400" long Bar

MR 10/06/11

8

0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per dwg D3262
Machine as per Folio FA902 and Dwg D3262
FOLIO REV: *AA*
DWG REV: *E*
Deburr

ST 10/06/14

MR 10/06/15

8

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

ISA 10/06/14

8

0



QC

Memo

0.00

MW 10/06/15

Quality Control

130

QC8- Inspect parts - second check

0.00

cmk 10/06/15

8

0



QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: *LG*

0.00



Packaging

Memo

0.00

8

0

BB 10/06/15

Packaging

W/O:		WORK ORDER CHANGES						
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Required Date: 6/18/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/17 *[Signature]*
mrf
10-6-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 10, 2010 10:38:47 AM

Page 1

Work Order ID: 59739



Parent Item: D3262-5



Parent Item Name: Cap

Start Date: 6/11/2010

Required Date: 6/18/2010

Comments: IPP REV:A NEW ISSUE 10-01-19 JLM VERIFIED BY:EC IPP
Rev:B as per ECN10-571 DD 10.05.10 verified :EC

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X06.00 0		Purchased	No			100	f	35.8695	0.96	10.10526			



6061-T6 Bar .500 x 6.00



Location

Loc Qty

Loc Code

MAT05

35.8695

110912

0.5945

112567

35.275

mf
10/06/10

4.725

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 59739
Description: Cap		Part Number: 3262-5
Inspection Dwg: D3262-5 Rev: E		Page 1 of 2

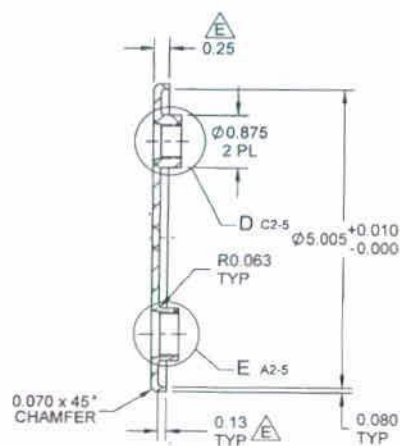
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

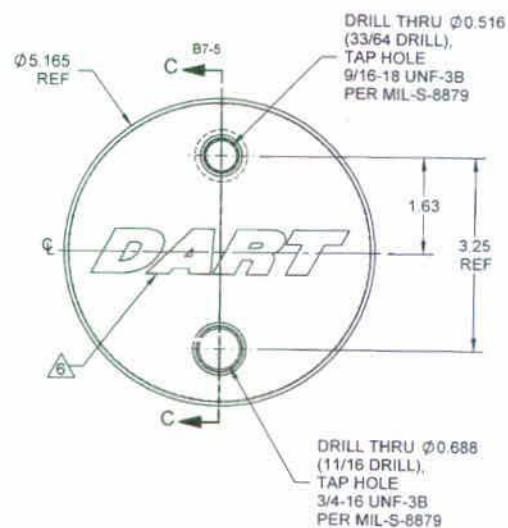
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5,165	$\pm 0,010$	5,166	✓			
9/16-18 UNF-3B	N/A					
1,63	$\pm 0,030$	1,63	✓			
3,25	$\pm 0,030$	3,25	✓			REF
3/4-16 UNF-3B	N/A					
0,25	$\pm 0,030$	0,248	✓			
0,875	$\pm 0,010$	0,876	✓			2PL
5,005	$+0,010/-0,000$	5,005	✓			
R0,063	$\pm 0,010$	0,062	✓			TYP
0,080	$\pm 0,010$	0,079	✓			TYP
0,13	$\pm 0,030$	0,130	✓			TYP
0,070 x 45°	$\pm 0,010 / \pm 1/2^\circ$	0,065 x 45°	✓			chamfer
0,588	$+0,005/-0,000$	0,590	✓			
0,696	$+0,007/-0,008$	0,700	✓			
0,091	$+0,007/-0,008$	0,096	✓			
R0,03	$\pm 0,010$	0,03	✓			
R0,02	$+0,000/-0,010$	0,02	✓			
45°	$\pm 1/2^\circ$	45°	✓			
30°	$\pm 1/2^\circ$	30°	✓			
0,45	$\pm 0,030$	0,445	✓			

Measured by: <i>DT</i>	Audited by: <i>am</i>	Prototype Approval:	N/A
Date: 10/06/14	Date: 10/06/15	Date:	N/A

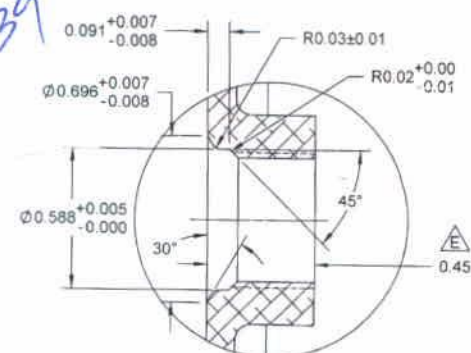
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



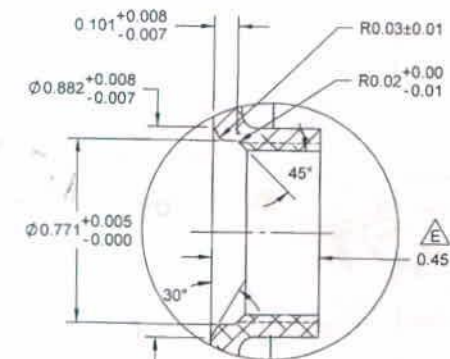
SECTION C-C D5-5



D3262-5 CAP



DETAIL D C7-5
SCALE 2X



DETAIL E B7-5
SCALE 2X

NOTES:

- 1) MATERIAL: 6061-T6/T651 ALUMINUM BAR
PER QQ-A-200/8 OR QQ-A-225/8
REF. DART SPEC. M5061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN
- 7) WEIGHT: 0.27 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. E
CHECKED	RF	D3262	SHEET 5 OF 5
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	FUEL PURGE CANISTER	NTS
DE APPR.	RF	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE FIRMEST CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.05.03		

RELEASED
2010-05-07

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